

Message Text

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TAGS: BEXP, PL

SUBJECT: PRIVATE TRADE OPPORTUNITY; SPECIAL HANDLING:
EQUIPMENT FOR MANUFACTURE AND TESTS OF STEEL/FORGED/
AND CAST STEEL VALVES, ASSEMBLY LINE.

1. 455/0026/P
2. 2/2/76
3. A. HERTZBERG
4. 455 POLAND
5. BIPROTOR, DESIGN OFFICE FOR PRODUCTION ORGANIZATION AND
ENGINEERING (BIURO PROJEKTOWANIA TECHNOLOGII I ORGANIZACJI
PRODUKCJI, BIPROTOR)
- 6A. REPLY TO---
- 6B. MR. W KOSMAL
- 6C. BIURO PROJEKTOWANIA TECHNOLOGII I ORGANIZACJI PRODUKCJI,
ONPROTOR /BIPROTOR, DESIGN OFFICE FOR PRODUCTION ORGANIZATION
AND ENGINEERING/
MODLINSKA STREET 15
03-216 WARSAW, POLAND
7. PHONE: 11 15 01 AND 11 15 21
8. N/A
9. 101
10. 35418XX - 1000 TECHNOLOGY, MACHINE TOOLS AND EQUIPMENT
FOR MACHINING OF VALVE BODIES, VALVE CAPS, VALVE SPINDLES,
VALVE HEADS AND OTHER VALVE PARTS. ASSEMBLY EQUIPMENT MUST
BE FULLY AUTOMATED (DEPENDING ON TECHNOLOGY AND ASSEMBLY
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LINE.)

38230XX-0100 VALVE-TEST EQUIPMENT DESIGNED TO MEET PARAMETERS AS FOLLOWS:

A) FOR WATER TIGHTNESS TEST OF VALVE BODY AND CAP, WATER TEMPERATURE MUST NOT EXCEED 40 DEGREES C. FOR DETAILED TEST DATA SEE TABLE 1

B) FOR CLOSURE TIGHTNESS TEST (WATER)-- WATER TEMPERATURE SHOULD NOT EXCEED 40 DEGREES C. PARTS TO BE TESTED SHOULD BE DE-AERATED TO AVOID DEFORMATIONS AND COMPRESSIVE STRESSES. TIGHTNESS IS TO BE TESTED BY USE OF MANOMETER FOR PARTS NOT EXCEEDING 150 MM IN DIAMETER. PRESSURE MUST NOT DROP MORE THAN ONE PERCENT DURING TEST.

FOR PARTS EXCEEDING 150 MM IN DIAMETER, CLOSURE TIGHTNESS TEST IS TO BE PERFORMED BY OBSERVING THE SEALING SURFACES. NO LEAKAGE MUST BE OBSERVED ON TEST SURFACES. FOR DETAILED TEST DATA SEE TABLE 1.

C) EQUIPMENT FOR ADDITIONAL TESTS:

- VALVE CAPS AND GATES ARE TO BE SUBJECTED TO AIR-TIGHTNESS TESTS. FOR TEST DATA SEE TABLE 2.

- STEAM TESTS ARE TO BE PERFORMED ON 2 OR 3 RANDOM SAMPLE UNITS. NO STEAM EJECTION IS ACCEPTABLE. PRODUCTS WITH POSITIVE WATER TESTS ARE SUBJECTED TO 5-MINUTE STEAM TESTS (HEATING TIME OF PRODUCTS TO BE TESTED IS NOT TO BE INCLUDED IN TEST TIME). FOR TEST DATA SEE TABLE 1 AND 2.

TABLE I (VALVE TESTING)

VALVE GATE DIAMETER

-MM	100	100-300	OVER 300
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TEST TIME

- MINUTES	2(MAX)	3(MAX)	5(MAX)
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NOMINALSRRESSURE

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- KG/CM2	40	64	100
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TEST PRESSURE

- KG/CM2	60	96	150
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CLOSURE TIGHTNESS TEST - WATER

TEST PRESSURE

- KG/CM2 40 64 100

TEST TIME

- MINUTES 2(MAX) 3(MAX) 5(MAX)

STEAM TEST

TEST PRESSURE

- KG/C.2 22 26 42

TEST TEMPERATURE

- DEGREES C 450 450 450

TABLE 2 (VALVE CAPST AND GATES)

AIR TIGHTNESS TEST

ASA STANDARDS 150 300 600 900

TEST PRESSURE

- KG/CM2 7 60 TO 80

WATER TEST

ASA STANDARDS 150 300 600 900

TEST PRESSURE

- KG/CM2 29.9 77.3 152.9 228.9

STEAM TEST

TEST PRESSURE

- KG/CM2 10.5 21.5 42.2 63.3

TEST TEMPERATURE

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- DEGREES C

A) CARBON STEEL 260 454 454 454

B) ALLOY STEEL 454 524 524 524

C) ACID-PROOF STEEL 607 607 607 607

INTERESTED FIRMS ARE REQUESTED TO MAIL SOONEST TECHNICAL LITERATURE, CATALOGS AND TENDERS INCLUDING PRICES DIRECTLY TO MR. W. KOSMAL AT BIPROTOR. TECHNICAL DRAWINGS AND PRODUCTION CAPACITY PROGRAM WILL BE MAILED TO TDAD UNDER SEPERATE COVER.

11. BIPROTOR HAS ALREADY CONTACTED GERMAN, FRENCH AND JAPANESE FIRMS. POLAND IS ALSO INTERESTED IN PRUCHASING EQUIPMENT FOR THE FOUNDRY AND FORGE WHICH WILL BE INTEGRATED INTO THE NEW PLANT. TRADE OPPORTUNITIES FOR THIS

EQUIPMENT WILL BE SENT SOON.

DAVIES

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